

shp 27/05 or sooner

Work Order ID 101884

101884

Page 1

May-21-13 7:48:08 AM

Item ID: D3467-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cover Plate LH

Start Date: 5/21/13

Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/24/13

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3467

Rev C

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3467 Dwg Rev: C Prog Rev: C

304.018

6 0 Jm13-5-21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 0 Jm13-5-21

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

0.00
22
13 S. 22

6 0

Work Order ID 101884

May-21-13 7:48:08 AM

101884

Page 2

Item ID: D3467-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cover Plate LH

Start Date: 5/21/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					6			SB 13/05/12
Small Fab	Memo	0.00							
Small Fab	I-Deburr2-Form as per dwg D3467								
140		0.00							
140	QC5- Inspect part completeness to step on W/O					6			
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: _____								
Packaging	Memo	0.00							
Packaging									

13-5-22

143/07/23 (6)

Work Order ID 101884

101884

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May-21-13 7:48:08 AM

Item ID: D3467-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cover Plate LH
 Start Date: 5/21/13 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/24/13 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

ML5 13-05-23

MF
13-5-23

Picklist Print

May-21-13 9:25:16 AM

Page 1

Work Order ID: 101884

Parent Item: D3467-1

Parent Item Name: Cover Plate LH

Start Date: 5/21/13

Required Date: 5/24/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.05.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S26GA		Purchased	No				sf	288.7400					
-----------	--	-----------	----	--	--	--	----	----------	--	--	--	--	--

304/316 0.018 SHEET

~~1.44~~
4.5

Jm135-21

Location

Loc Qty

Loc Code

MAT020

288.74

117798

69.28

122753

97.06

123135

122.4

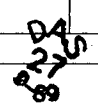
122753


DART AEROSPACE LTD		Work Order:	101884
Description: Cover Plate, LH		Part Number:	D3467-1
Inspection Dwg: D3467	Rev: B C	13.05.21	
		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

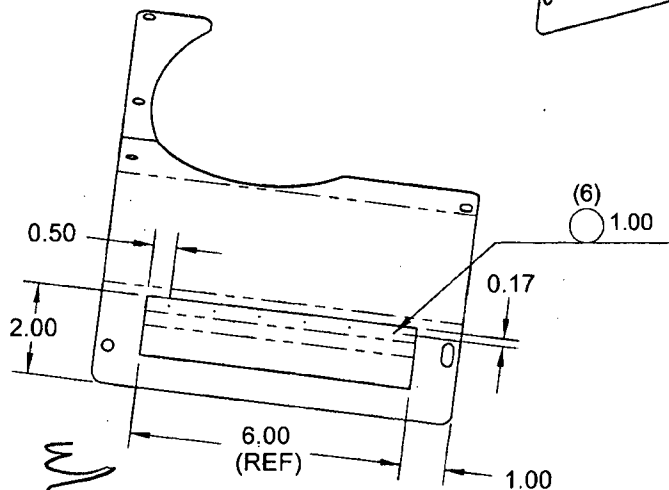
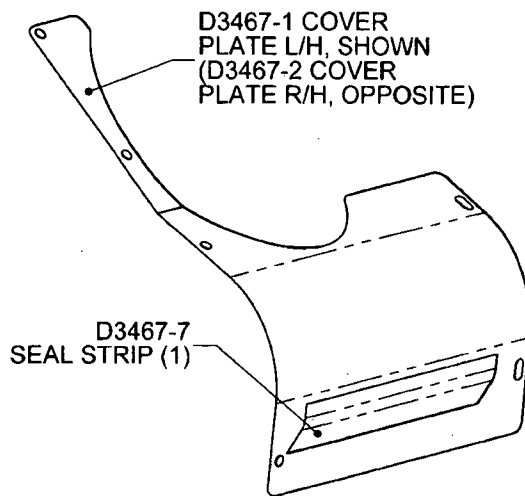
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.250 x 0.500 0.500	+0.005/-0.001	0.255" x 0.505"	-		✓	Jlmaol
Ø0.250	+0.005/-0.001	0.253"	-		✓	
0.813	+/-0.010	0.818"	-		✓	
6.550	+/-0.010	6.554"	-		✓	
9.530	+/-0.010	9.531"	-		✓	Produced
13.005	+/-0.010	13.005"	-		T	Jlmaol
13.255	+/-0.010	13.255"	-		T	
0.280	+/-0.010	0.287"	-		✓	
1.650	+/-0.010	1.645"	-		✓	
7.750	+/-0.010	7.754"	-		✓	
8.000	+/-0.010	8.007"	-		✓	
1.200 1.250	+/-0.010	1.242"	-		✓	
5.500 5.600	+/-0.010	5.597"	-		✓	
6.974	+/-0.010	6.971"	-		✓	
0.018	+/-0.010	0.019"	-		✓	

Measured by: Jm	Audited by: 	Prototype Approval:	N/A
Date: 13-5-21	Date: 13 5 21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD 	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C SHEET 4 OF 15
DATE 08.12.19	TITLE SHROUD ASSEMBLY	SCALE 1:4	

RELEASED
09/01/30 [Signature]

30°
(REF)

D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

NOTES:





- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO
0.010

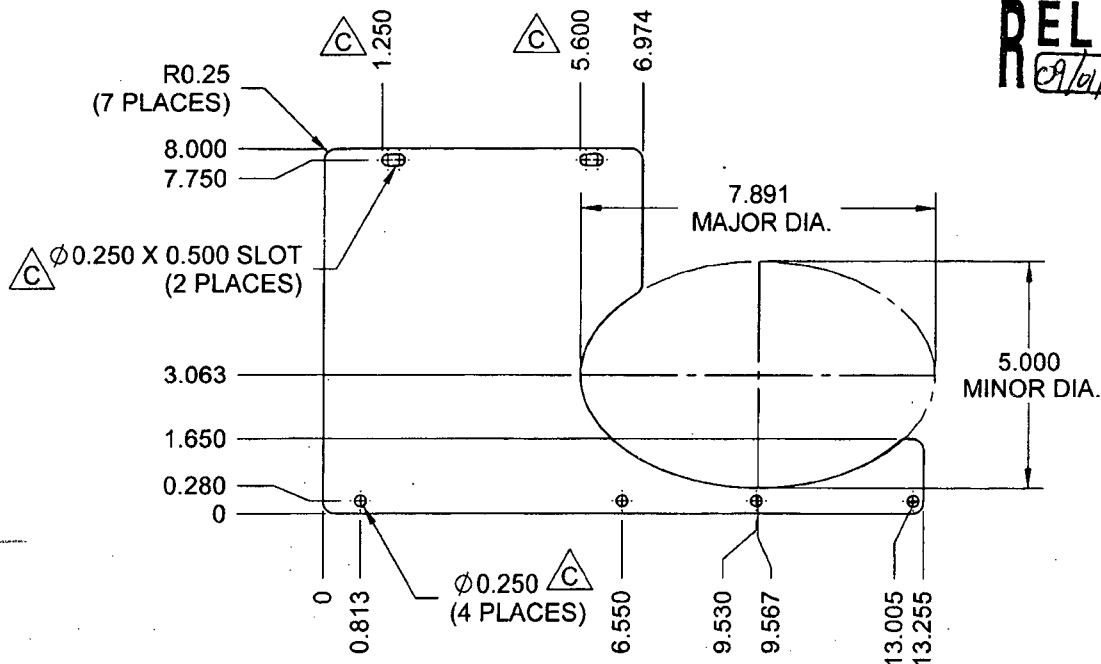
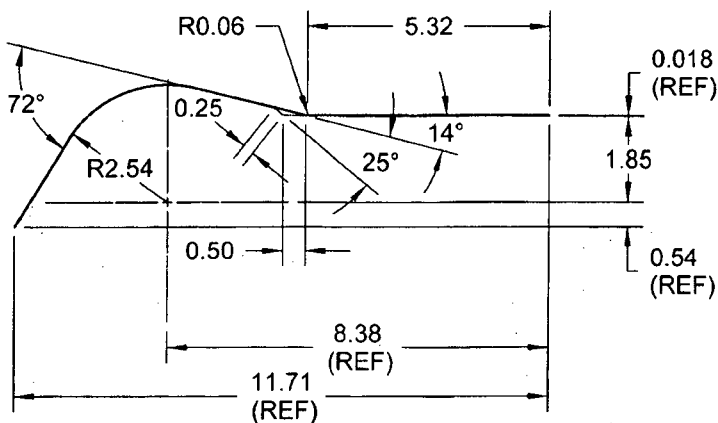
QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP


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DART

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3467	REV. C SHEET 6 OF 15
DATE 08.12.19		TITLE SHROUD ASSEMBLY	SCALE 1:4

**RELEASED**
29/01/30 N/A**D3467-1F COVER PLATE FLAT PATTERN****D3467-1 L/H COVER
PLATE ISOMETRIC VIEW.
D3467-2 R/H COVER
PLATE (OPPOSITE)
SCALE 1:8****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH 
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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